4/19/63

Stanley Industrial Tool Company
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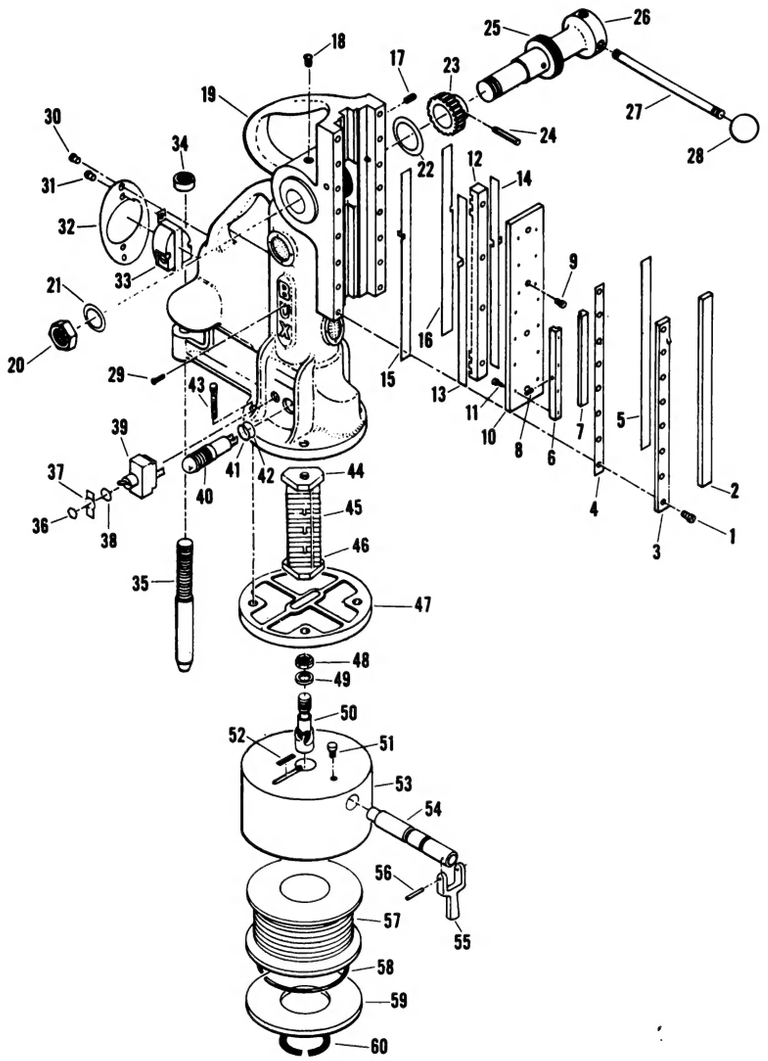
BUX magnetic products



BUX ELECTRO-MAGNETIC DRILL PRESSES
MODELS L-2RP AND L-3RP

ORDERING OF PARTS

The parts price list should be referred to when ordering replacement parts. ALWAYS INCLUDE COMPLETE NAMEPLATE DATA WHEN ORDERING REPLACEMENT PARTS. Parts may be purchased from your BUX Authorized Service Station or from the factory.

PARTS LIST

Index No.	Part No. L-2RP	Part No. L-3RP		Qty.
1	1144	1144	SCREW (MS 35228-64)	14-20
2	1164	3064	BAR, Slide Retainer	1
3	1165	3065	BAR, Slide Retainer & Stop	1
4-5	1180	3066	STRIP, Slide Wear	1 ea.
6	1017	1017	BAR, Torque, Left	1
7	1018	1018	BAR, Torque, Right	1
8	1124	1124	SCREW, Set	1
9	1166	1166	SCREW (MS35270-62)	4-5
10	1031	3031	SLIDE	1
11	1158	1158	SCREW, Mach. Fil. Hd., Phillips 10-32x½	8
12	2016	3016	RACK	1
13	1061L	3061L	STRIP, Gib, Side, Left	1
14	1061R	3061R	STRIP, Gib, Side, Right	1
15	1150L	3062L	STRIP, Gib, Back, Left	1
16	1150R	3062R	STRIP, Gib, Back, Right	1
17	1124	1124	SCREW SET, Nylok	6-9
18	1079	1079	SCREW, Mach., Rd. Hd. 10-32x¼	2
19	2042	3069	POST ASSEMBLY	1
20	8065	8065	HEX NUT (ESNA)	1
21	3122	3122	WASHER, Shim	1
22	3116	3116	SEAL, "O" Ring	1
23	2011	2011	GEAR, Pinion	1
24	2012	2012	PIN, Roll (ESNA)	1
25	8106	8106	DEPTH GAUGE RING with Decal.	1
26	3142	3142	SHAFT, Pinion	1
27	1041	3041	ROD, Handle	4
28	1042	1042	BALL, Handle	4
29	1090	1090	SCREW, Parker-Kalon, Type A #4x¾	1
30	1076	1076	SCREW, Mach., Rd. Hd. 8-32x¼	2
31	1076	1076	SCREW, Mach., Rd. Hd. 8-32x¼	2
32	3113	3113	RECEPTACLE, Cover Plate	1
33	1035	1035	RECEPTACLE	1
34	1064	1064	NUT, Knurled	1
35	1047	3047	STABILIZER LEG	1
36	—	—	HEX NUT	1
37	1117	1117	PLATE, Switch Indicator	1
39	1138	1138	SWITCH, Toggle	1
40	1139	1139	LAMPHOLDER ASSEMBLY	1
41	—	—	LOCK WASHER	1
42	—	—	SHIM, Washer	1
43	1183	3073	SCREW, Cap	4
44	2027	3013	BRACKET, Rect. Mount., Top (110 volt)	1
	2027	3013	BRACKET, Rect. Mount., Top (220 volt)	1
45	1025	1025	RECTIFIER (110 volt)	1
	2210	2210	RECTIFIER (220 volt)	1
46	2028	3328	BRACKET, Rect. Mount., Bot. (110 volt)	1
	2028	3328	BRACKET, Rect. Mount., Bot. (220 volt)	1
47	2512	8141	PLATE, Dead	1
48	3520	3520	HEX NUT, Locking (Fleyloc)	1
49	3519	3519	WASHER, Steel	1
50	3515	3515	STUD, Aligning	1
51	8187	8187	SCREW, Allen Hd. Cap Screw 8-32x¼	1
52	2524	2524	STRIP, Steel	1
53	2536	3536	POLE PIECE	1
54	8186	8186	SHAFT, Cam	1
55	3503	3503	HANDLE	1
56	3524	3524	PIN, Roll (ESNA)	1
57	2532	8094	COIL, Assembly (110 volt)	1
	2250	8221	COIL, Assembly (220 volt)	1
58	8078	8078	"O" RING, Spacer	1
59	2528	8115	PLATE, Retainer	1
60	2527	8096	SPRING, Lock Ring	1
	8086	8086	CABLE, Power, 110/220v (not shown)	1
	3119	3119	BUSHING, Cord Strain, Relief (Heyco) (Not Shown)	1

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LITHO IN U.S.A.

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OPERATING AND MAINTENANCE INSTRUCTIONS

OPERATION

The BUX Electro-Magnetic Drill Press may be operated in any position—vertical, horizontal, or inverted. Before attempting to operate the drill press, however, you must understand the following principles of operation.

DRILLING THIN AND NON-FERROUS MATERIAL ... The electro-magnet contained in the drill press operates at its nominal gripping power on material ½-inch or more thick, as shown in the graph below. To drill thin or non-ferrous material, simply place a ½-inch thick plate against the back of the material. This plate should be 6 by 6 inches or larger. When the magnet is energized by turning on the switch, the plate and the drill press will be held securely in place.

SURFACE ... It is *not* necessary to have a clean, smooth, or unpainted surface to operate the press. However, for drilling large holes without a pilot hole, remove any loose rust, grime, or dirt in order to assure maximum drill point pressure.

ENERGIZING THE ELECTRO-MAGNET ... Place the drill press on the material to be drilled near the punch mark. Turn the power switch ON. This applies full power to the magnet coil.

RADIAL POSITIONING ... With the drill press held firmly in position on the material to be drilled, simply loosen the locking cam by rotating the handle on the side of the magnet. The drill press is then easily turned through 330 degrees and can be positively locked in any position by tightening the handle. The handle will also release the drill press for maximum lateral (fore and aft) movement.

DRILLING IN HORIZONTAL OR OVERHEAD POSITIONS ... If drilling in a horizontal or overhead position, hold the press with your left hand on the magnet switch. Hold the press with your right hand on the pinion shaft hub so that a twist of the wrist will move the drill bit in and out enough to locate the bit on the punch mark. Place the drill press near the punch mark and turn on the magnet switch. Position the drill radially. *Always use a safety chain or cable when drilling in overhead positions.* If the power source fails, the press will drop. The safety chain should be positioned so that the press would drop away from the operator.

OPERATING SEQUENCE

1. Place the press on the material to be drilled.
2. Turn on the magnet switch.
3. Loosen the radial positioning handle and locate the drill bit exactly on the punch mark.
4. Loosen the knurled nut and adjust the stabilizer leg to come into firm contact with the material being drilled and hand-tighten the knurled nut.
5. Turn on the drill and apply pressure lightly to the feed handles in direct line with the bit until a full cut is obtained, then increase pressure to complete the drilling.

SERVICE AND MAINTENANCE

LUBRICATION ... Oil all moving and sliding surfaces on the drill stand daily with a few drops of high grade motor oil. To oil the pinion shaft bushings, remove the two oil hole screws located directly above the centerline of the pinion shaft and put a few drops of oil in each hole. Always replace the screws. Oil the contacting surfaces on the slide and rack by moving the slide to the extreme up and down position.

DISASSEMBLY ... Remove the drill and disconnect it from the drill press before starting disassembly.

PINION SHAFT ... Remove the hex nut on the end of the pinion shaft. Pull the pinion shaft (with the pinion gear) out of the drill post.

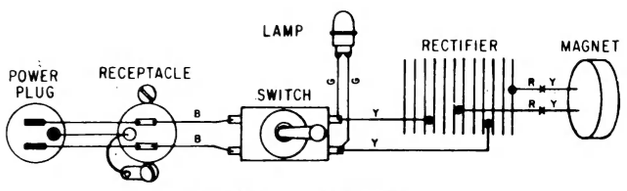
SLIDE AND RACK ... Remove the stop screw from torque bar. Pull the slide and rack up until it comes out of the retainer bars and drill post.

DRILL POST AND ELECTRICAL COMPONENTS ... Remove the four cap screws holding the drill post to the magnet pole piece. Facing the front (slide) of the drill press, lean the drill post to the left, keeping it close to the magnet so as not to place a strain on the wires running between the post and the magnet. With the post lying on its side, disconnect the two wires running between the post and the magnet. The magnet and swivel assembly will be released from the press for further disassembly. Remove the drill cord receptacle and disconnect the wiring. Remove the strain clip on the power input cord for the drill press and pull the cord out of the drill post. Remove screw located left side of post approximately half way up, then withdraw rectifier from post cavity. Disconnect wiring to the rectifier terminals. In order to properly install a new rectifier, be sure the "AC" or input power leads are connected to the yellow color coded terminals. The "DC" output terminals are color coded black and red respectively and may be connected to the load with either polarity.

Special care should be taken in the radial positioner type units to insure that all slack is removed from coil leads to prevent them from being crimped.

RADIAL POSITIONER ASSEMBLY ... Remove the locking nut from the aligning stud on top of the pole piece and lift off the washer and dead plate. The cam shaft assembly is held in place by a ¼" socket head cap screw that is screwed into the top of the pole piece. Remove screw and withdraw cam shaft assembly. Remove carefully steel strip (part #52) which secures lead wires in milled slot. Remove aligning stud and withdraw carefully leads that are threaded up through same in a plastic insulated sleeve.

ELECTRO-MAGNETIC COIL ... To remove coil, first remove lock ring from groove on pole piece center. Then remove retainer plate and coil will come right out easily.



MODEL L WIRING